

Date: Tuesday, 19/08/2008 4:07:54 PM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : TUBE HANDLE
<b>Job Number</b> : 41519	
<b>Estimate Number</b> : 13444	
<b>P.O. Number</b> :	<b>Part Number</b> : PB674300191
<b>This Issue</b> : 19/08/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : B6743001 P.30
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : 1/1 <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : B1
<b>Previous Run</b> : 41216	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 18/09/2008 <b>Qty:</b> 20 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>Jul 08.8.20</u>	
<b>Comment</b> : Est Rev:A 08-06-26 new issue DD verified by:ec	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M6061T6T100W125 <i>ST</i>	6061 RD TUBE 1.00 x .125w
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*\**  
**Comment:** Qty.: 0.4375 f(s)/Unit Total : 8.7507 f(s)

6061 TUBE

batch:

~~M109854~~  
*M18147(8)*

*M110885 (14)*

*SAD 09-01-25*

*20*

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

- 1- cut to length as per dwg
- 2- make a 0.090" chamfer on both ends of tube
- 3- deburr

*SAD 09-01-25 20*

3.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP

*S 09/02/23 (420) center*

4.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Identify and Stock

Location:

*ST 446*

*SS 09/02/23 (420)*

5.0	QC21	FINAL INSPECTION/W/O RELEASE
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**Comment:** FINAL INSPECTION/W/O RELEASE

*09/02/24*

Job Completion



*MF 09-02-23*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

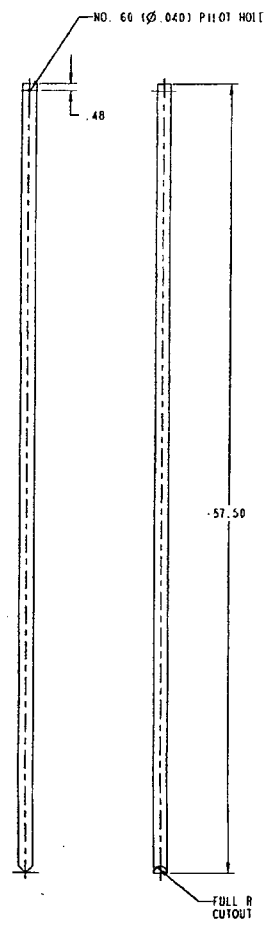
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

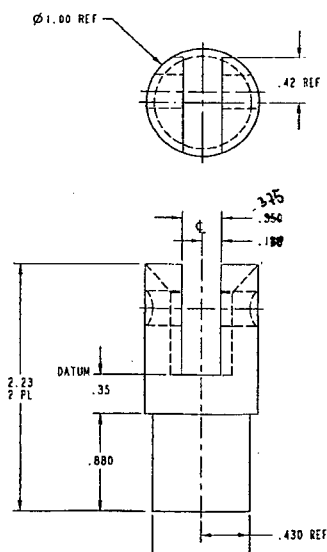
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

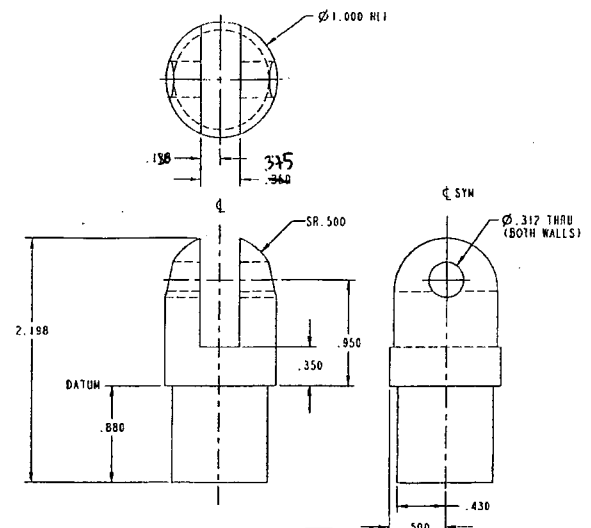
RELEASED  
77-06-01-20



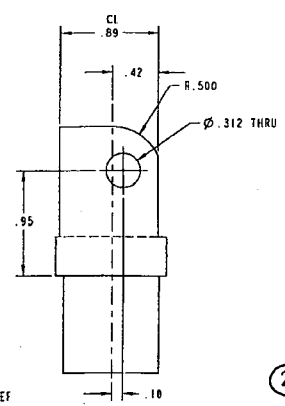
① -87 TUBE ARM  
MATE: 1.00 OD X .065 WALL, 6061-T6, WW-T-700/6  
SCALE 0.250



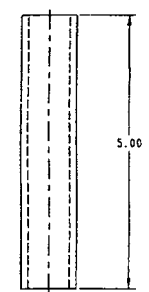
① -89 CLEVIS  
MATE: 1.00 RND, 6061-T6, 00-A-200/8  
SCALE 2.000



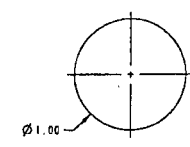
-97 CLEVIS (SHOWN)  
MATE: 1.00 RND, 6061-T6, 00-A-225/8  
SCALE 2.000



② -93 TUBE END CAP  
MATE: .063 THK, 6061-T6, 00-A-250/11  
SCALE 2.000



① -91 TUBE HANDLE  
MATE: 1.00 OD X .125 WALL, 6061-T6, 00-A-200/8  
SCALE 1.000



PREMIER AVIATION, INC.  
200 Aviation Parkway, Grand Prairie, Texas 75050  
DATE: 08/08/88 BY: D/SUV8 B67-43001 REV: 87  
SCALE: 1.00 UNIT: 30.48

ORIGINAL

NO. 41519  
WITHOUT

UNCONTROLLED  
ENGINE  
RETURN  
SUBJECT TO 7